

Work Order ID 134320

134320

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Wednesday, July 08, 2015 3:09:22 PM

Item ID: D3371-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Tail Rotor Pedal Lock
Start Date: 7/07/15 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 7/07/15 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MCS Date: JUL 09 2015 Cooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120 0.00
120 Small Fab
Small Fab Memo 0.05
Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
4- Assemble lock mechanism and cam and install decal as per Dwg D3371.
Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>17132202</u>

130 0.00
130 Small Fab
Small Fab Memo 0.02
Small Fab Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

2 FF NOV 26 2015

2 FF NOV 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Required Date: 7/07/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ 15-11-27
MLJ 15-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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134320

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-028		Purchased	No			120	Each	87.0000	2	4			
238-028									**				
3/16" Dowel Pin .5" long													

Location	Loc Qty	Loc Code
ST568	87	
M132062	87	

AN526C832R6		Purchased	No			120	Each	64.0000	4	8			
AN526C832R6									**				
Screw													

Location	Loc Qty	Loc Code
GA	64	
m131379	64	

CBL-1240		Purchased	No			130	f	552.0772	1.6666	3.508632			
CBL-1240									**				
Cable													

Location	Loc Qty	Loc Code
GA	552.0772	
m130006	52.0772	
m132518	500	

CBL-460		Purchased	No			130	Each	250.0000	2	4			
CBL-460									**				
Loop Sleeve													

Location	Loc Qty	Loc Code
GA	250	
m131619	250	

NOV 25 2015

NOV 26 2015

NOV 26 2015

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
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Picklist Print

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Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

D3371-1 Manufactured No

120 Each 1.0000 1 2

D3371-1

Pedal Lock Base

133791 SP

Location

Loc Qty

Loc Code

ST498

1

109067

1

D3371-3 Manufactured No

120 Each 4.0000 1 2

D3371-3

Pedal Lock Cover

Location

Loc Qty

Loc Code

ST498

4

104353

4

D3373-7 Manufactured No

120 Each 13.0000 1 2

D3373-7

Cam Lock

Location

Loc Qty

Loc Code

ST036

13

123528

2

94791

11

D3384-1 Manufactured No

130 Each 7.0000 1 2

D3384-1

Cyclic Sock

Location

Loc Qty

Loc Code

ST500

7

123313

1

133088

6

**DAG
6
9-89**

**DAG
6
9-89**

**DAG
6
9-89**

NOV 25 2015

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Shop Packet Print

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DQA: _____ Date: _____



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D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

D3385-3 Manufactured No

120 Each 26.0000 1 2

DAG
6
9.00

D3385-3

Hinge

Location

Loc Qty

Loc Code

ST036

26

117534

26

2

HX-81 Purchased No

140 Each 64.0000 1 2

DAG
6
9.00

HX-81

1/4"-20 SHCS 3/8" long

Location

Loc Qty

Loc Code

ST554

64

123436

64

2

NAS1149F0463P Purchased No

140 Each 1,248.000 2 4

DAG
6
9.00

NAS1149F0463P

Washer

Location

Loc Qty

Loc Code

ST260a

977

m127832

977

st268

271

m127832

247

m130388

24

2

NOV 25 2015

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